

Date: Thursday, 05/02/2009 3:30:31 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT LH DOOR HINGE KIT
Job Number :	45530		
Estimate Number :	13765		
P.O. Number :		Part Number :	D130780011
This Issue :	05/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	IIN-D130-780
First Issue :	//	Project Number :	N/A
Previous Run :		Drawing Revision :	A
	Type : MACHINED PARTS	Material :	
Written By :		Due Date :	28/02/2009
Checked & Approved By :	JLD 09.02.06	Qty:	1 Um: Each
Comment :	Est Rev:A 09-02-03 new issue DD verified by:JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL *for JLD 09/03/06*
ECN 09-541 added

Photocopy bluefile and type labels per PPP D130-780-011 CHG 001 *5 02/05/06*

2.0	D3813041	Hinge Assembly, Upper Door
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Assembly, Upper Door

batch: *45727*

3.0	D3813043	Hinge Assembly, Lower Door
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Assembly, Lower Door

batch: *45728*

4.0	D38141	Hinge, Upper Airframe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge, Upper Airframe

batch: *45673*

5.0	D38143	Hinge, Lower Airframe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge, Lower Airframe

batch: *45674*

5b 1x D3892-1 B 47330 per ECN 09-541

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:30:31 PM
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Job Number: 45530

Part Number: D130780011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D38161

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Spacer
batch: 45675

SS 09/05/05 (X1)

7.0

D38163

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Spacer
batch: 45676

SS 09/05/05 (X1)

8.0

D3817041

Anchor Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Anchor Nut Plate
batch: 43730

SS 09/05/05 (X1)

9.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt
batch: M 165057

SS 09/05/05 (X1)

10.0

AN37A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)
Bolt
batch: M 110704

SS 09/05/05 (X1)

11.0

AN3104

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
NUT
batch: M 111060

SS 09/05/05 (X1)

12.0

AN417

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt
batch: M 111499

SS 09/05/05 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45530

Part Number: D130780011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN9704

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch:

M110704

14.0

MS21042L3

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nut

batch:

M110844

15.0

MS24665212

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cotter Pin

batch:

111499

16.0

MS24694S46

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Screw

batch:

M111499

17.0

NAS1149D0363J

Washer



AN9605D10
QSI17



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch:

M110985

No Qty's

18.0

NAS1149D0463J

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch:

M110914

19.0

D35527

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Door Prop

batch:

32644

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Part Number: D130780011

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D36221

Ball Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Ball Stud

batch: 46451

21.0

D38201

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

batch: B45732

22.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M169840

23.0

NAS1149D0563J

Washer



AN9603D516
QSI 17



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M110523

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D130-780-011

Location:

PPP Rev: A

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	Part Number	Description
X						D130-780-041	SPACEPOD™ LH, EC 130 B4
	X					D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X				D130-780-043	DOOR ASSEMBLY, LH
	1		X			D130-780-044	DOOR ASSEMBLY, RH
1				X		D130-780-011	AFT LH DOOR HINGE KIT
1	1				X	D130-780-013	SWITCH RELOCATION KIT
2	2					D3815-041	WEB ASSEMBLY
						D2464-0360	NEOPRENE SEAL
		1	1			D2589	KEYS, KEY CHAIN
1	1					D3837-1	DECAL
1	1					D3015-3	LOCK NUT
		1				D3186-3	SPACEPOD™ DOOR, LH
			1			D3186-4	SPACEPOD™ DOOR, RH
1						D3798-041	FLOOR
	1					D3798-042	FLOOR
1						D3188-5	SPACEPOD™ BODY
	1					D3188-6	SPACEPOD™ BODY
1	1					D3547-1	BRACKET
1	1					D3550-1	STRUT
		1	1			D3552-7	GAS SPRING
1	1					D3554-7	BALL STUD
4	4					AN3-3A	BOLT
4	4					AN3-6A	BOLT
2	2					AN3-10A	BOLT
1	1					AN5-5A	BOLT
38	38					AN525-10R7	SCREW
8	8					AN526C832R14	SCREW
7	7					MS24694S67	SCREW
1	1					MS24694S69	SCREW
		2	2			MS27039-0811	SCREW
8	8					A3235-020-935	WASHER
8	8					NAS1149D0363J	WASHER
16	16					NAS1149D0332J	WASHER
		4	4			NAS1149DN832J	WASHER
3	3					NAS1149D0563J	WASHER
		2	2			NAS1515H3	NYLON WASHER
		2	2			MS21042L08	NUT
16	16					MS21042L3	NUT (or MS21042-3)
1	1					MS21042L5	NUT
10	10					AKS7-1032-130	INSERT
28**	28**					AKS7-1032-130	INSERT
					2	D3819-1	MALE SPADE CONNECTOR
					2	D3597-1	FEMALE SPADE CONNECTOR

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Revision: A

Date: 08.10.07

R5530

-041	-042	-043	-044	-011	-013	Part Number	Description
					1	D3598-2-096	EXPANDABLE SLEEVE
					24	D3599-1	TIE-WRAP
					24	D3600-1	TIE-WRAP MOUNT
					24 FT	M22759/41-22-9	WIRE
		1*	1*			D2464-1250	NEOPRENE SEAL
1**		1*				D3837-3	DECAL
	1**		1*			D3837-4	DECAL
		2*	2*			D2586	LATCH
		2*	2*			D2585	MOUNTING CHANNEL
		2*	2*			D2621	LATCH PLATE
		2*	2*			MS27039-1-15	SCREW
		2*	2*			NAS1149D0363J	WASHER
		2*	2*			MS21042L3	NUT (or MS21042-3)
		1*	1*			D2857-1	HINGE BRACKET
		1*	1*			D2857-2	HINGE BRACKET
		2*	2*			D2228	BACKING PLATE
		8*	8*			AN526C832R10	SCREW
		8*	8*			NAS1149DN832J	WASHER
		8*	8*			MS21042L08	NUT
		1*	1*			D3557-1	BRACKET
		2*	2*			D2228	BACKING PLATE
		1*	1*			D3554-7	BALL STUD
		1*	1*			NAS1149D0563J	WASHER
		1*	1*			D3015-3	LOCK NUT
		2*	2*			AN526C832R14	SCREW
		2*	2*			AN526C832R10	SCREW
		4*	4*			NAS1149DN832J	WASHER
		4*	4*			MS21042L08	NUT
2**	2**					D2237	STRIKER PLATE
4**	4**					MS20426AD4-5	RIVET
2**	2**					D3538-1	HINGE BRACKET
2**	2**					D2179	HINGE BRACKET PLATE
4**	4**					AN526C832R24	SCREW
4**	4**					NAS1149DN832J	WASHER
4**	4**					MS21042L08	NUT
				1		D3813-041	HINGE ASSEMBLY, UPPER DOOR.
				1		D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***		D3518-3	ROD END
				2***		NAS509-6	NUT
				1		D3814-1	HINGE, UPPER AIRFRAME
				1		D3814-3	HINGE, LOWER AIRFRAME

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Revision: A

Date: 08.10.07

NO 45530

-041	-042	-043	-044	-011	-013	Part Number	Description
				2		D3816-1	SPACER
				4		D3816-3	SPACER
				1		D3817-041	ANCHOR PLATE
				2		AN3-5A	BOLT
				3		AN3-7A	BOLT
				2		AN310-4	CASTLE NUT
				2		AN4-17	BOLT
				2		AN970-4	WASHER
				5		MS21042L3	NUT
				2		MS24665-212	COTTER PIN
				3		MS24694S46	SCREW
				8		NAS1149D0363J	WASHER
				2		NAS1149D0463J	WASHER
				1		D3552-7	GAS SPRING
				2		D3622-1	BALL STUD
				1		D3820-1	DOOR SUPPORT
				2		MS21042L5	NUT
				2		NAS1149D0563J	WASHER

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

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Revision: A

Date: 08.10.2008

NO. 207530

SHOOT COPY

08.10.2008

08.10.2008

08.10.2008

08.10.2008

08.10.2008

08.10.2008

08.10.2008

08.10.2008

08.10.2008

08.10.2008